

Table 1. Level 1 Component and Composition Changes for Immediate Release Oral Solid Dosage Forms

Excipient	Percent Excipient (w/w) Out of Total Target Dosage Form Weight
Filler	+/- 5%
Disintegrant	
starch	+/- 3%
other	+/- 1%
Binder	+/- 0.5%
Lubricant	
calcium or magnesium stearate	+/- 0.25%
other	+/- 1%
Glidant	
talc	+/- 1%
other	+/- 0.1%
Film coat	+/- 1%

Table 2. Level 2 Component and Composition Changes for Immediate Release Oral Solid Dosage Forms

Excipient	Percent Excipient (w/w) Out of Total Target Dosage Form Weight
Filler	+/- 10%
Disintegrant	
starch	+/- 6%
other	+/- 2%
Binder	+/- 1%
Lubricant	
calcium or magnesium stearate	+/- 0.5%
other	+/- 2%
Glidant	
talc	+/- 2%
other	+/- 0.2%
Film coat	+/- 2%

Figure 1

Table 3. Level 3 Component and Composition Changes for Immediate Release Oral Solid Dosage Forms

Excipient	Percent Excipient (w/w) Out of Total Target Dosage Form Weight
Filler	Greater than +/- 10%
Disintegrant	
starch	Greater than +/- 6%
other	Greater than +/- 2%
Binder	Greater than +/- 1%
Lubricant	
calcium or magnesium stearate	Greater than +/- 0.5%
other	Greater than +/- 2%
Glidant	
talc	Greater than +/- 2%
other	Greater than +/- 0.2%
Film coat	Greater than +/- 2%

Table 4. Level 1 Component and Composition Changes for Modified Release Oral Solid Dosage Forms (nonrelease controlling excipient)

Excipient	Percent Excipient (w/w) Out of Total Target Dosage Form Weight
Filler	+/- 5%
Disintegrant	
starch	+/- 3%
other	+/- 1%
Binder	+/- 0.5%
Lubricant	
calcium or magnesium stearate	+/- 0.25%
other	+/- 1%
Glidant	
talc	+/- 1%
other	+/- 0.1%
Film coat	+/- 1%

Figure 2

Table 5. Level 2 Component and Composition Changes for Modified Release Oral Solid Dosage Forms (nonrelease controlling excipient)

Excipient	Percent Excipient (w/w) Out of Total Target Dosage Form Weight
Filler	+/- 10%
Disintegrant	
starch	+/- 6%
other	+/- 2%
Binder	+/- 1%
Lubricant	
calcium or magnesium stearate	+/- 0.5%
other	+/- 2%
Glidant	
talc	+/- 2%
other	+/- 0.2%
Film coat	+/- 2%

Table 6. Level 3 Component and Composition Changes for Modified Release Oral Solid Dosage Forms (nonrelease controlling excipient)

Excipient	Percent Excipient (w/w) Out of Total Target Dosage Form Weight
Filler	Greater than +/- 10%
Disintegrant	
starch	Greater than +/- 6%
other	Greater than +/- 2%
Binder	Greater than +/- 1%
Lubricant	
calcium or magnesium stearate	Greater than +/- 0.5%
other	Greater than +/- 2%
Glidant	
talc	Greater than +/- 2%
other	Greater than +/- 0.2%
Film coat	Greater than +/- 2%

Figure 3

Table 7. Level 1 Component and Composition Changes for Modified Release Oral Solid Dosage Forms (release controlling excipient)

Excipient	Percent Excipient (w/w) Out of Total Release Controlling Excipient Content in the Modified Release Solid Oral Dosage Form
Any release controlling excipient(s)	+/- 5%

Table 8. Level 2 Component and Composition Changes for Modified Release Oral Solid Dosage Forms (release controlling excipient)

Excipient	Percent Excipient (w/w) Out of Total Release Controlling Excipient Content in the Modified Release Solid Oral Dosage Form
Any release controlling excipient(s)	+/- 10%

Table 9. Level 3 Component and Composition Changes for Modified Release Oral Solid Dosage Forms (release controlling excipient)

Excipient	Percent Excipient (w/w) Out of Total Release Controlling Excipient Content in the Modified Release Solid Oral Dosage Form
Any release controlling excipient(s)	Greater than +/- 10%

Figure 4

Table 10. Schematic of use within the commercial pipeline

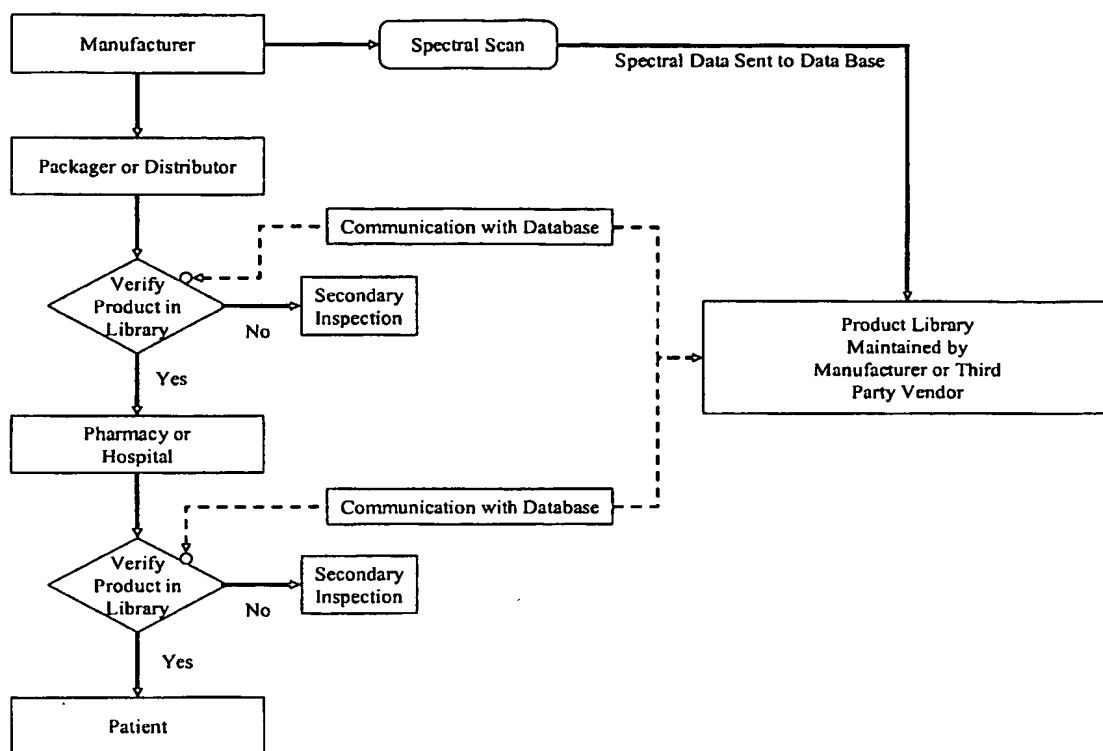


Figure 5

Table 11. Composition of Aspirin Formulations

Component	Formulation A1 (mg/tab)	Formulation A2 (mg/tab)	Formulation A3 (mg/tab)
Aspirin	325	325	325
Microcrystalline cellulose	73	83	63
Magnesium stearate	2	2	2
TOTAL WEIGHT	400	410	390

Table 12. Composition of Prednisone Formulations

Component	Formulation B1 (mg/tab)	Formulation B2 (mg/tab)	Formulation B3 (mg/tab)
Prednisone	5	5	5
Microcrystalline cellulose	94.5	94.5	94.5
Magnesium stearate	0.5	0.75	0.25
TOTAL WEIGHT	100	100.25	99.75

Table 13. Composition of Indomethacin Formulations

Component	Formulation C1 (mg/tab)	Formulation C2 (mg/tab)	Formulation C3 (mg/tab)
Indomethacin	25	25	25
Microcrystalline cellulose	71.5	74	69
Croscarmellose sodium	3	2	4
Magnesium stearate	0.5	0.5	0.5
TOTAL WEIGHT	100	101.5	98.5

Table 14. Compositions of Acyclovir Formulations

Component	Formulation D1 (mg/tab)	Formulation D2 (mg/tab)	Formulation D3 (mg/tab)
Acyclovir	200	200	200
Microcrystalline cellulose	113.26	120.26	106.26
Starch	35	27.99	41.99
Magnesium stearate	1.75	1.75	1.75
TOTAL WEIGHT	350	350	350

Figure 6

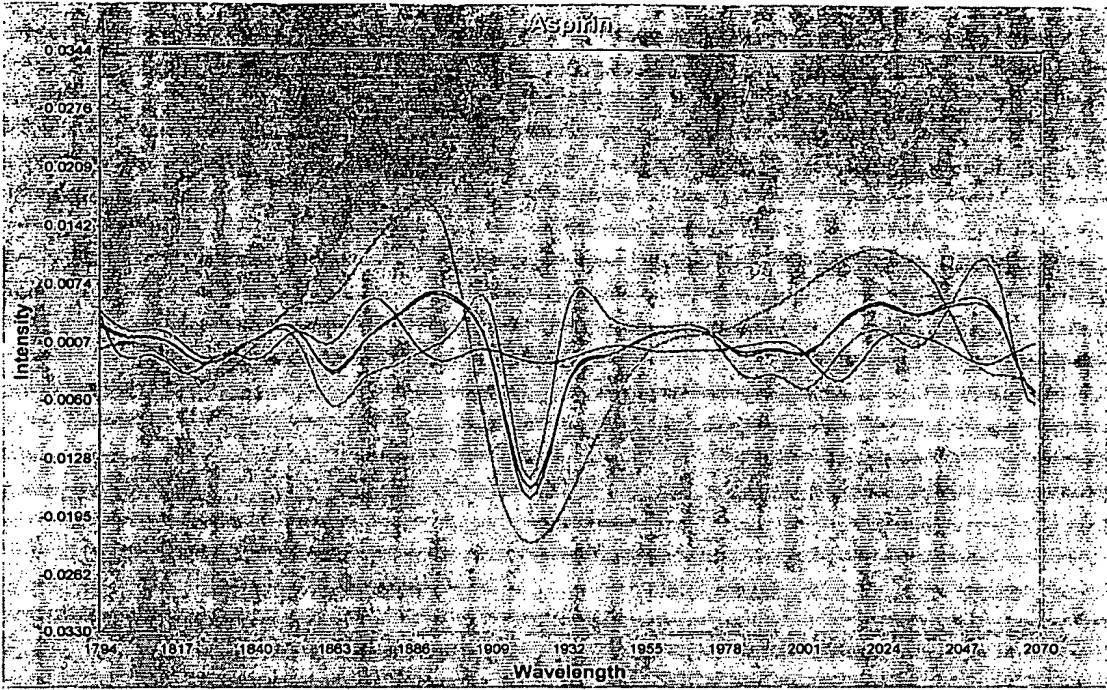


Table 15. 2nd Derivative of Absorbance vs. Wavelength: Aspirin Formulations

Figure 7

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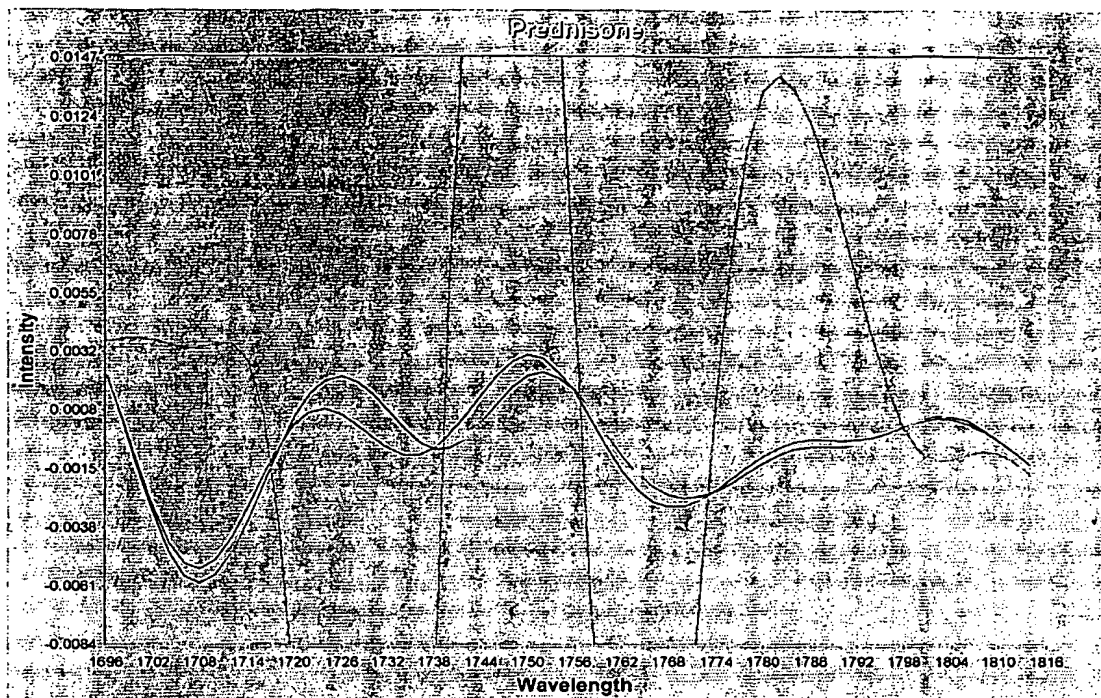


Table 16. 2nd Derivative of Absorbance vs. Wavelength: Prednisone Formulations

Figure 8

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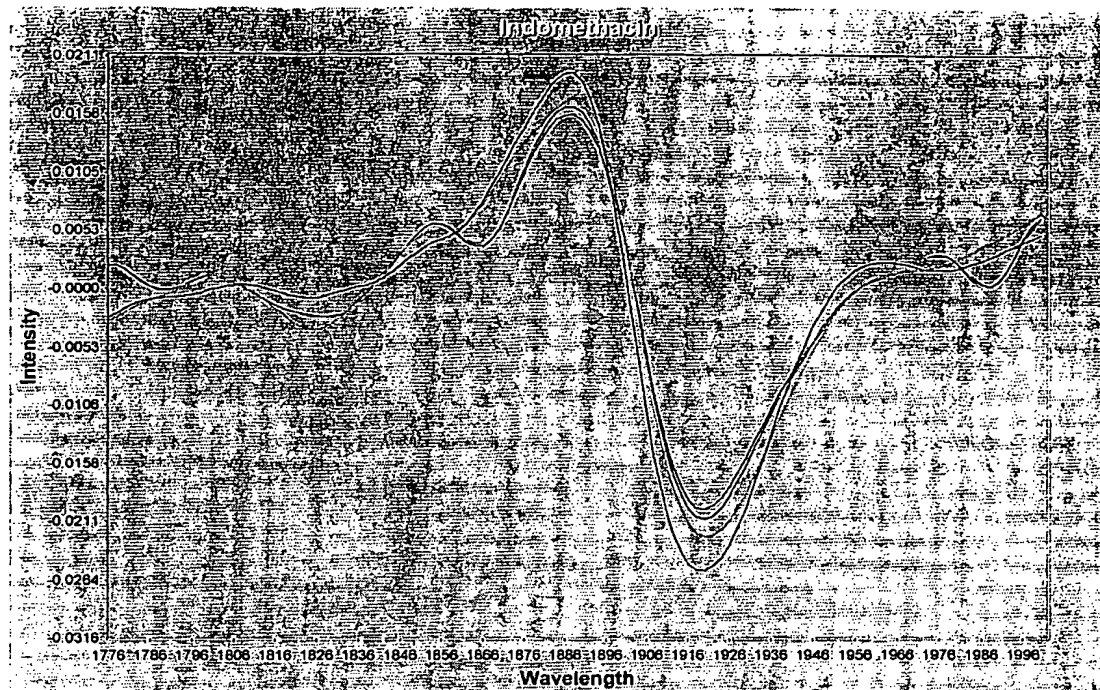


Table 17. 2nd Derivative of Absorbance vs. Wavelength: Indomethacin Formulations

Figure 9

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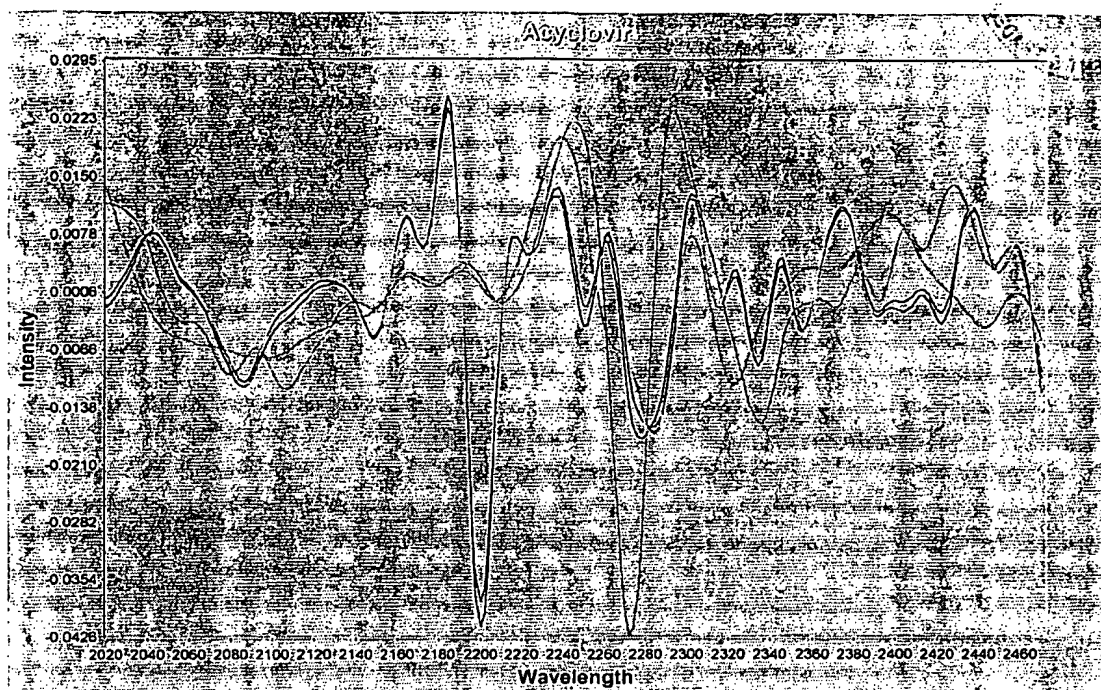


Table 18. 2nd Derivative of Absorbance vs. Wavelength: Acyclovir Formulations

Figure 10

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